

Work Order ID 133165

133165

Page 1

Tuesday, May 26, 2015 12:49:22 PM

Item ID: D2435 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 5/26/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/26/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: MAY 27 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								

120

120

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

CUT BLANK AS PER FILE D2435

0.00

0.00

4 0 JUN 5-28

130

130

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Debur

0.00

0.00

4 0 DAS 25 9-89 15-68

140

140

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

4 0 DAS 25 9-89 15-68

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Page 2

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 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 5/26/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/26/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150						4	0		DAS 08 9-89
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
151									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

4X
 JUN 17 2015

MCS
 JUN 18 2015

MCS
 JUN 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 1

Tuesday, May 26, 2015 12:49:21 PM

Work Order ID: 133165

133165

Parent Item: D2435

D2435

Parent Item Name: Bearpaw

Start Date: 5/26/15

Required Date: 5/26/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	443.0420	3.2	12.8			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

Jm15-5-28

Location

Loc Qty

Loc Code

MAT

387.175

m131661

57.175

m132063

330

132063

MAT018

55.867

m131335

55.867

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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OTHER : _____					

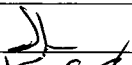
DART AEROSPACE LTD		Work Order:	133165
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.06x45°	✓		Vern	SL-10
B	5.500	+/-0.030	5.503	✓			
C	0.200	+/-0.030	.198	✓			
D	R0.250	+/-0.030	.250	✓			
E	0.250	+/-0.010	.249	✓			
F	0.625	+/-0.030	.630	✓			
G	0.25 x 45°	+/-0.030	.26x45°	✓			
H	0.375	+/-0.010	.378	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	.952	✓			
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.930	+/-0.030	.930	✓			
M	0.30	+0.030/-0.000	.315	✓			
N	0.375	+/-0.030	.380	✓			
O	7.375	+/-0.030	7.375	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	2.018	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓			

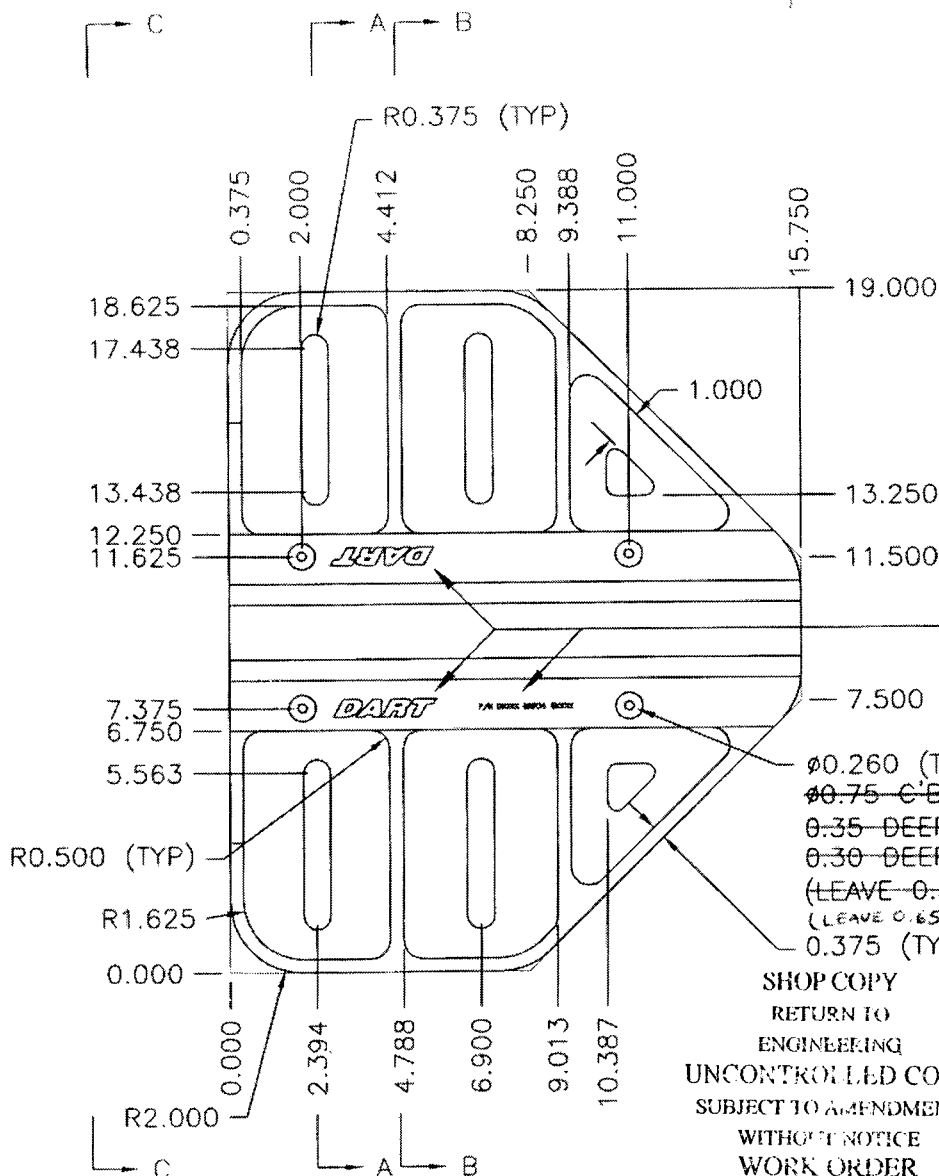
Measured by:		Audited by:	M.A.	DAS		Prototype Approval:	N/A
Date:	15-68	Date:	15/06/10	08	9-89	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

DA COM
ISSUED

1980-06-17 KEE

DESIGN	DRAWING BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E SHEET 1 OF 2
CHECKED	APPROVED			
DATE			TITLE	SCALE
98.05.19			BEARPAW	1:5
A		96.01.24	NEW ISSUE	
B		96.03.26	CHANGE BORE AND C'BORE DEPTH	
C		97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D		97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E		98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	



ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133165 MU

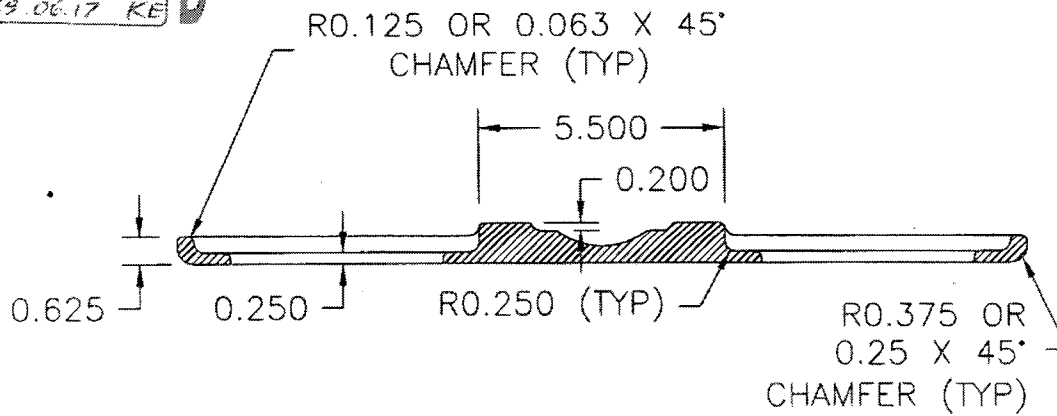
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

Copyright 1996 by DART AEROSPACE LTD

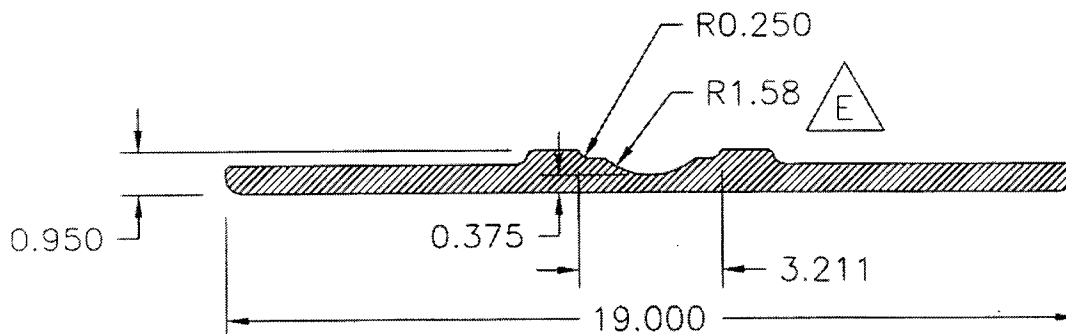


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

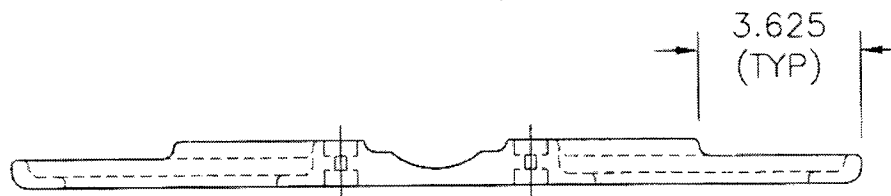
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C